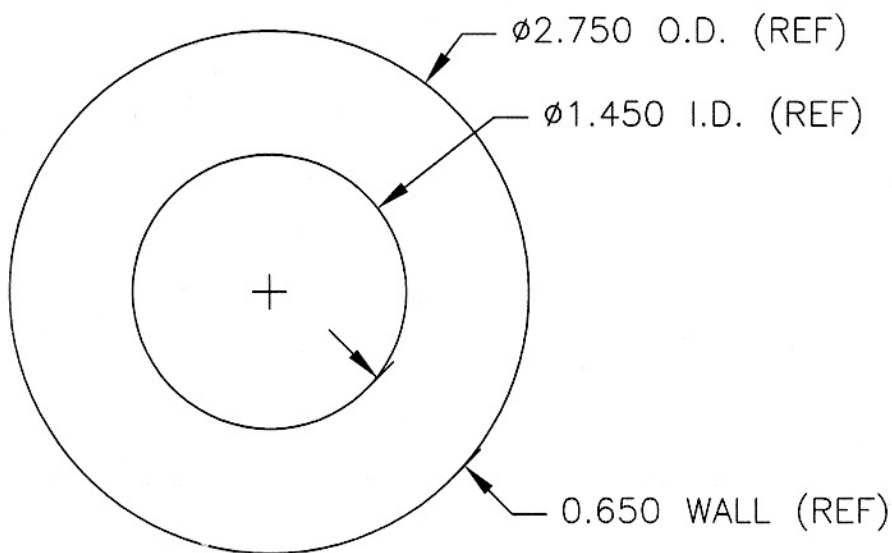




DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6011	REV. A SHEET 1 OF 1
DATE 01.08.16		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	01.08.16	NEW ISSUE	
A1	01.08.16 02-01-29	UPDATE TOLERANCE ON OD	

SPECIFICATION CONTROL DRAWING


RELEASED
01.08.17 *[Signature]*



NOTES

- 1) D6011-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 115" LONG TUBE: D6011-115

- 2) MATERIAL: 2.750 OD x 0.650 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ~~ASTM B210~~ AS FOLLOWS: *ANSI H35.2 AS FOLLOWS* 
O.D.: ± 0.006 MEAN (± 0.012 INCLUDING OVALITY) ± 0.015 MEAN (± 0.030 INCL. OVALITY)
WALL: ± 0.020 MEAN (± 0.065 INCLUDING ECCENTRICITY)
LENGTH: XXX +0.125/-0.000
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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